

Date: Monday, 6/19/2006 11:24:55 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 27611		
Estimate Number	: 10366		
P.O. Number	: N/A	Part Number	: D412742013
This Issue	: 6/19/2006	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: N/A
Previous Run	: 27610	Material	: N/A
		Due Date	: 7/20/2006
Written By	:	Qty:	1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 & DSI 9330 & DSI 9336 CHG001

KS 06-07-14 ①

2.0	27611A	FLOAT SKID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component FLOAT SKID ASSEMBLY

B27613

3.0	D2571	Saddle, Fwd, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 1	D2571	Saddle Fwd Outside	B27992

4.0	D2572	Saddle, Fwd, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 1	D2572	Saddle Fwd Inside	B27762

5.0	D2573	Saddle, Aft, Out
-----	-------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 1	D2573	Saddle Aft Outside	B27763

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:24:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 27611

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D2574	Saddle, Aft, In
-----	-------	-----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle Aft Outside	B27890

7.0	D2747	Set Screw
-----	-------	-----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2747	Bolt	B27631

8.0	D2876	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2876	Saddle Spacer	B26367

9.0	D2877	Saddle Spacer
-----	-------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2877	Saddle Spacer	B26513

10.0	D34031	Bushing
------	--------	---------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
16	D3403-1	Bushing	B26794 9MCP ✓ B28067 7MCP ✓

11.0	D34033	Bushing
------	--------	---------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
8	D3403-3	Bushing	B26795

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:24:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 27611

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 1 D3405-041

GHW Lug

B26514

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 1 D3405-043

GHW Lug

B26515

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 16 AN4C6A

Bolt

M100651

15.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 4 AN4C46A

Bolt

M19529

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 8 AN4C52A

Bolt

M19512

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 8 AN6C12A

Bolt

M101467

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:24:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 27611

Part Number: D412742013

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

18.0	AN960C416L	WASHER
------	------------	--------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 32	AN960C416L	Washer	M100651

19.0	AN960C616L	WASHER
------	------------	--------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 8	AN960C616L	Washer	M18822

20.0	AN960C716L	WASHER
------	------------	--------



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 16	AN960C716L	Washer	M100579 ✓

21.0	MS210434	Nut
------	----------	-----



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
✓ 29	MS21043-4Nut		M101390 ✓

✓ 22.0	NAS1515H4L	Inventory
--------	------------	-----------



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
32	NAS1515H4L	Washer	M100854 25 mcp 7 PAS info ✓ M18918 7 mcp → 5. RT ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:24:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 27611

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

NAS1515H6L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 8 NAS1515H6L

Washer

M18918 ✓

24.0

NAS1515H7L

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 16 NAS1515H7L

Washer

M100722 ✓

25.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 1 D3407-041

TOW RING

B28321 ✓

26.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 2 D3417-3

WASHER

B27571 ✓

27.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

✓ 1 D3456-1

WASHER

B25701 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:24:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 27611

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

✓ Batch: M11196

04/10/05 (1)

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



06/10/05 (1)

Comment: INSPECT 100% KITS FOR COMPLETENESS

06/10/05 (1)

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: REUB

04/10/05 (1)

31.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/05 (1)

Job Completion



06-10-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:25:10 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 27611A		
Estimate Number	: 10756		
P.O. Number	: N/A	Part Number	: D412742043
This Issue	: 6/19/2006	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3391 REV D
First Issue	: N/A	Project Number	: N/A
Previous Run	: 27610A	Drawing Revision	: DE 06-06-19 EH
	Type	Material	: N/A
	: LANDING GEAR	Due Date	: 7/20/2006
Written By	: <u>[Signature]</u>	Qty:	1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM		
	: Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,
 Photocopy bluefile and create labels per PPP D412-742-043 CHG001

N/A

2.0	D25775	Wearplate, Centre
-----	--------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D2577-5 Wearplate B24199

3.0	D3391021	Fwd Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-021 Fwd Tube Assembly B26847

4.0	D3391023	Mid Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

pick:

Qty Part Number Description Batch

1 D3391-023 Mid Tube Assembly B26577

DL 06/08/25

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:25:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 27611A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
1	D3391-025	Aft Tube Assembly	B26578

6.0

D34601

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
1	D3460-1	Wearplate	B26622

7.0

D34603

WEARPLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
1	D3460-3	Wearplate	B25643

check Inv.

8.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
24	AN3C4A	Bolt	m101390

FC

9.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
12	AN3C6A	Bolt	m101291

FC 06 08 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:25:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 27611A

Part Number: D412742043

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	AN3C7A	BOLT
------	--------	------



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
8	AN3C7A	Bolt	<u>M10124</u>

FC

11.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
44	AN960C10L	Washer	<u>M100186</u>

FC

12.0	NAS1515H3L	WASHER
------	------------	--------



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)
pick:

Qty	Part Number	Description	Batch
44	NAS1515H3L	Washer	<u>M19099</u>

FC 06 08 28 (1)

13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
------	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391
A/R LPS-3 M101092 9... 06-08-31 (1)

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M101953
Expiry date: 10/04

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".
Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M17168
A/R Sikaflex-241/-291 M101953
Expiry date: 10/04

4-Remove "T" pins once sikaflex is dry.

PL 06 08 31 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/09/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 6/19/2006 11:25:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 27611A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

DL 06/08/31

14.0

QC5

INSPECT WORK TO CURRENT STEP



For 09.05 0



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

N/A

16.0

DC

DOCUMENT CONTROL



0

Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/09/10

Job Completion



U 06/09/12

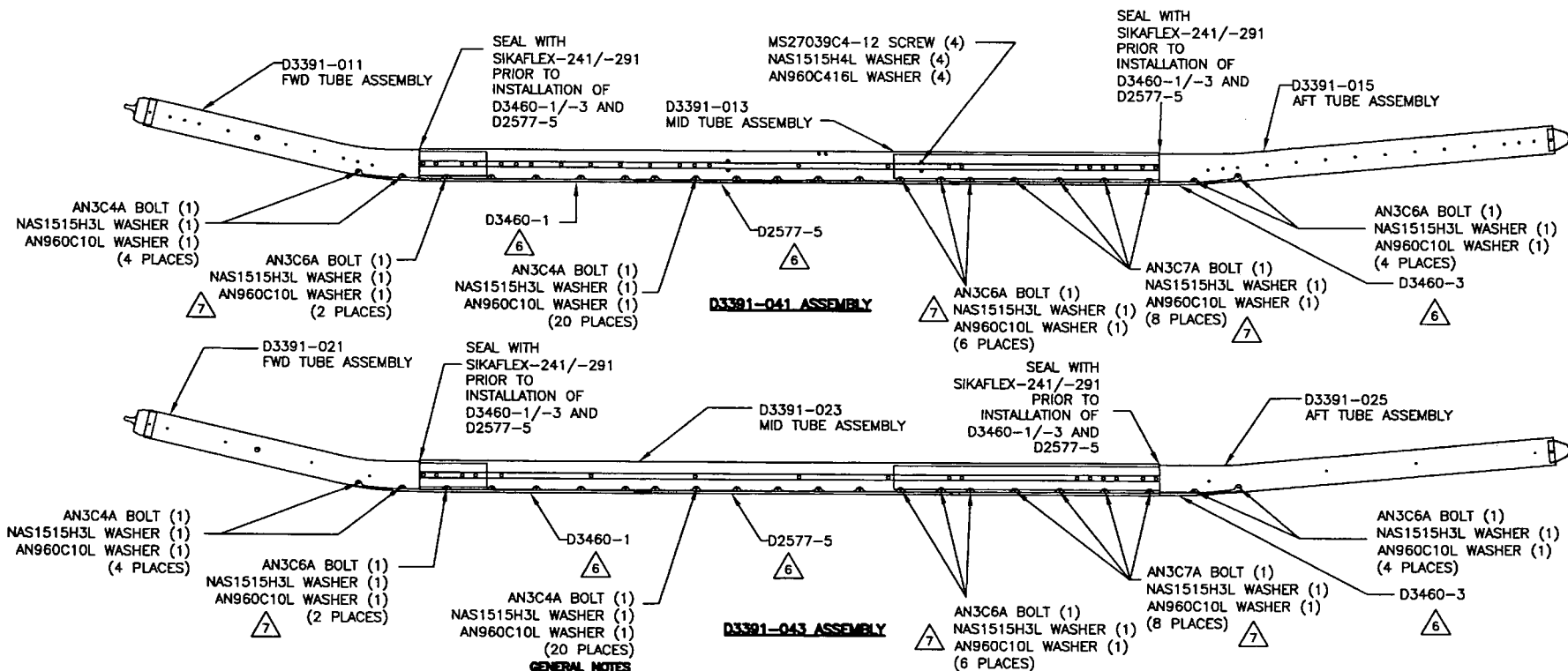
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
24		AN3C4A	BOLT
12		AN3C6A	BOLT
8		AN3C7A	BOLT
44		NAS1515H3L	WASHER
44		AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
1	1	D2577-5	WEARSHOE
1	1	D3460-1	WEARSHOE
1	1	D3480-3	WEARSHOE

- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL "E" SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES
- DO NOT TORQUE, HAND TIGHTEN ONLY

RELEASED

06-05-03

E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	06.04.25	TITLE
		412 FLOAT SKIDTUBE
		NTS

COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
PORT HADLOCK, OH

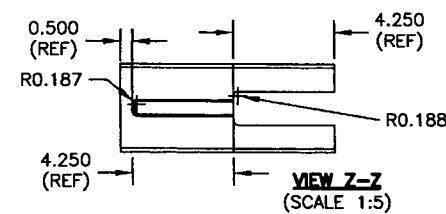
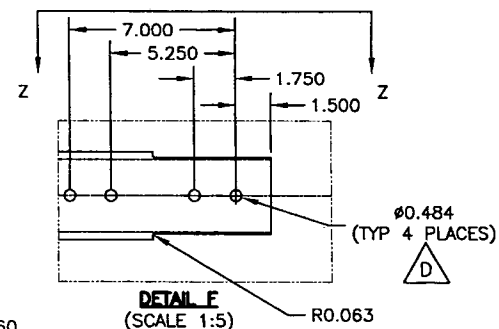
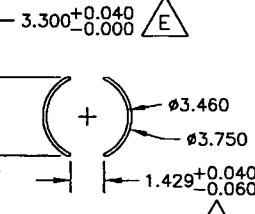
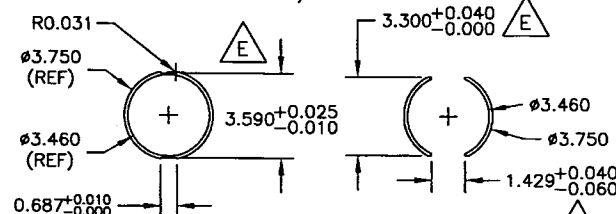
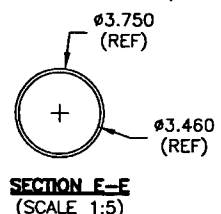
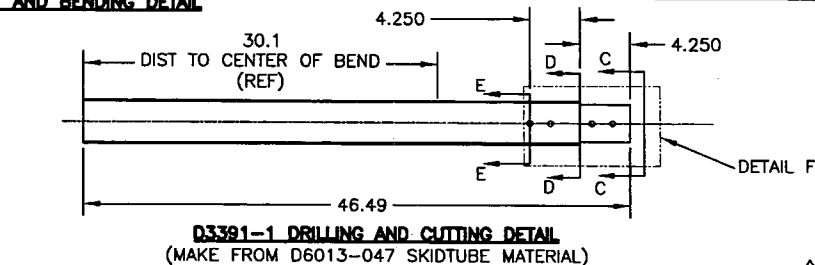
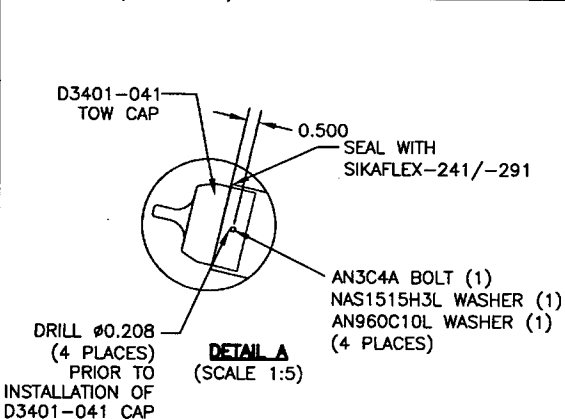
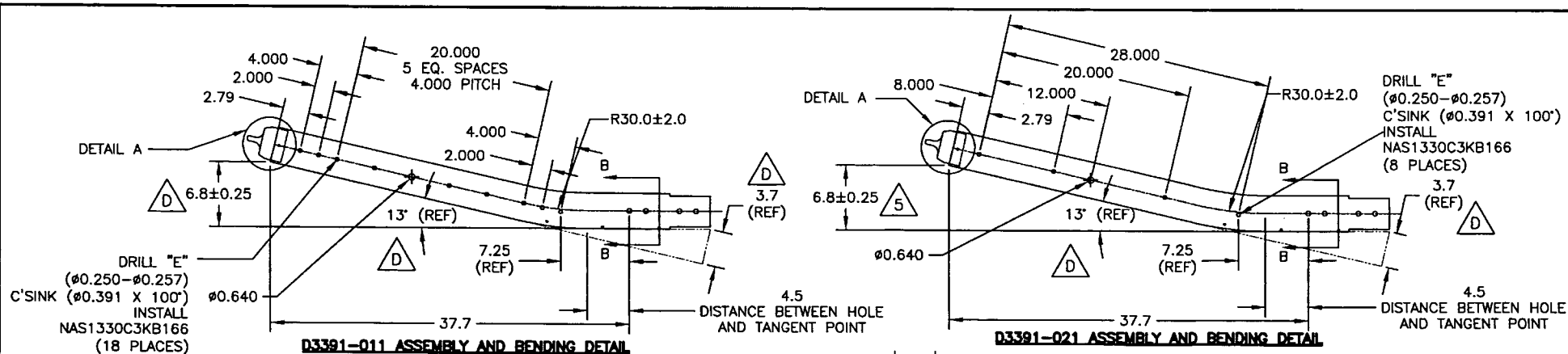
DRAWING NO. D3391

REV. E

SHEET 1 OF 5

SCALE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 27611A
SHOP COPY
RETURN TO
ENGINEERING



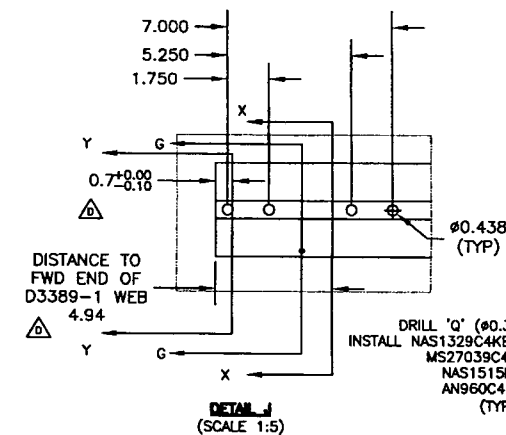
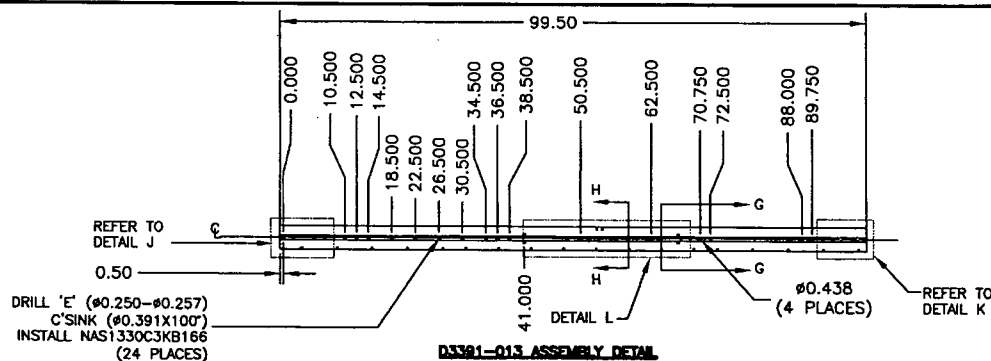
D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
4	4	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
4	4	AN980C10L	WASHER
24	14	NAS1330C3KB166	INSERT

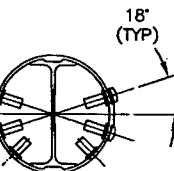
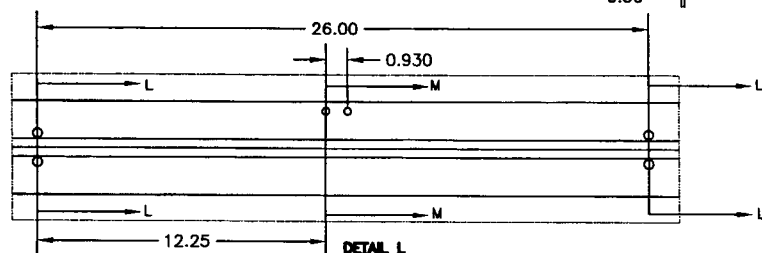
NO. 27611A
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
RETURN TO
SHOP COPY
ENGINEERING

DESIGN PH		DRAWN BY PH		DART DART AEROSPACE USA, INC.	
CHECKED #	APPROVED #	DRAWING NO. D3391		REV. E	
DATE 06.04.25		TITLE 412 FLOAT SKIDTUBE		SHEET 2 OF 5	
				SCALE 1:10	

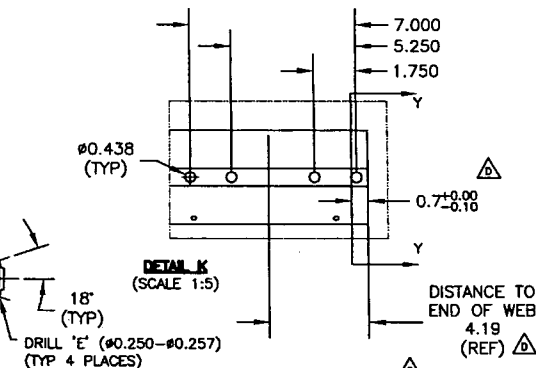
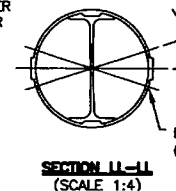
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



DRILL 'Q' (#0.332-#0.338)
INSTALL NAS1329C4KB140 INSERT
MS27039C4-08 SCREW
NAS1515H4L WASHER
AN960C416L WASHER
(TYP 4 PLACES)



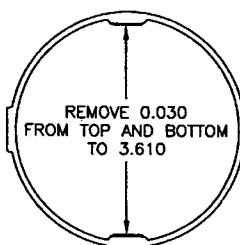
DRILL 'E' (#0.250-#0.257)
C'SINK (#0.391X100")
INSTALL NAS1330C3KB116 INSERT
MS27039C1-08 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 4 PLACES)



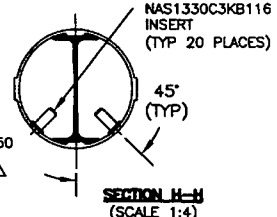
RELEASED
06.05.01

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330C3KB116	INSERT
24	10	NAS1330C3KB166	INSERT
4		NAS1329C4KB140	INSERT
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-08	SCREW
4		MS27039C4-08	SCREW



REMOVE 0.225
FROM TOP AND BOTTOM
TO 3.800
(0.7 FROM BOTH ENDS)



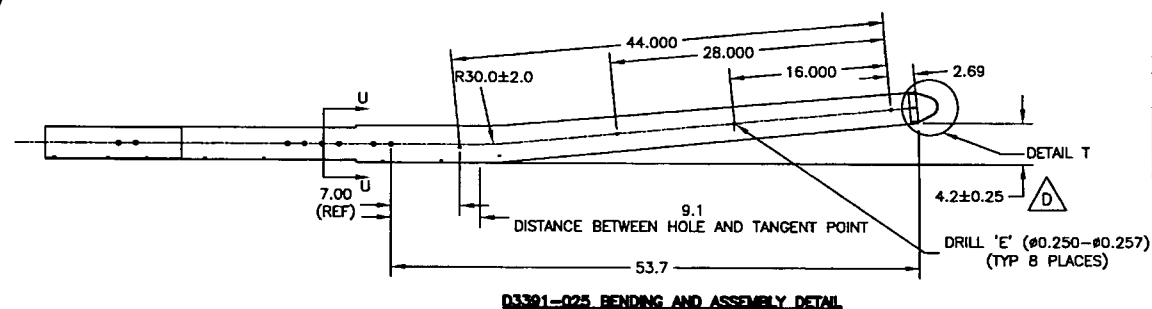
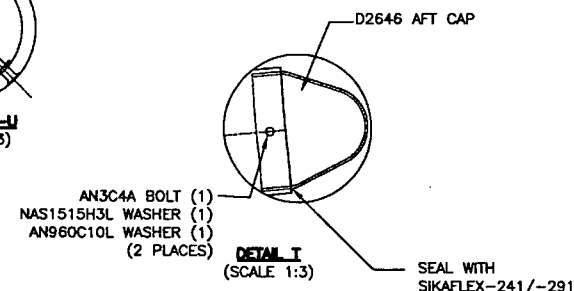
D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-41/2291 PER QSI 015

UNCONTROLLED COPY
RETURN TO
ENGINEERING
FOR AMENDMENT
WITHOUT NOTICE
WORK ORDER
27611A

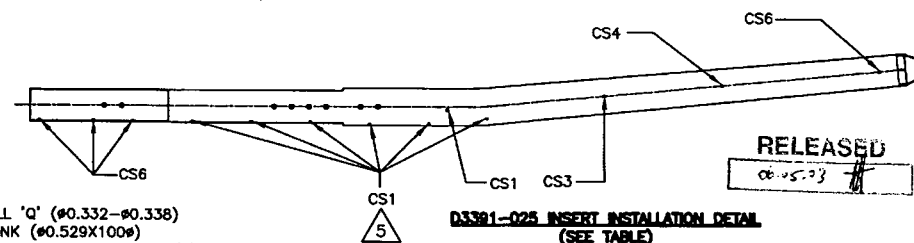
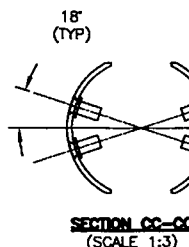
COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

DESIGN PH	DRAWN BY PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED #	APPROVED #	DRAWING NO. D3391
DATE 06.04.25	TITLE 412 FLOAT SKIDTUBE	REV. E SHEET 3 OF 5 SCALE 1:20



HC ES MARKED	QTY D3381-315	CTY D3391-025	C'SINK	P'N
CS1	18	14	Q2425	AESS10KB366
CS2	4		Q2391	AESS10KB366
CS3	4	2	Q2391	NA51350C3KE316
CS4	4	2	Q2391	NA51350C3KE266
CS5	4		Q2391	NA51350C3KE216
CS6	12	8	Q2391	NA51350C3KE166

QTY - 016	QTY - 025	PART NUMBER	DESCRIPTION
X		D3361-015	AFT TUBE ASSEMBLY
	X	D3361-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
18	14	AESS10KB366	INSERT
4	2	NAS1330C3KB318	INSERT
4	2	NAS1330C3KB268	INSERT
4		NAS1330C3KB216	INSERT
12	8	NAS1330C3KB166	INSERT
4		NAS1330C4KB151	INSERT
2	2	AN3C4A	BOLT
2	2	NAS1515H3L	WASHER
2	2	AN66C10L	WASHER



DRILL 'Q' (#0.332-#0.338)
C'SINK (#0.529X100#)
NAS1330C4KB151 INSERT (1)
(4 PLACES)

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL
AND IS SUPPLIED ON THE EXPRESS CONDITION
THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.

TITLE	412 FLOAT SKIDTUBE
-------	--------------------

SHEET 5 OF 5

SCALE

1:12